#### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 99.28

# WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-021690

Address: 333 Burma Road **Date Inspected:** 06-Mar-2011

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai

**CWI Name:** Tian Lei, Liu Fa Wen **CWI Present:** Yes No **Inspected CWI report:** Yes **Rod Oven in Use:** Yes No No N/A N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes N/A **Delayed / Cancelled:** No

34-0006 **Bridge No: Component:** OBG

## **Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

## Bay Number 1

This inspector observed ZPMC QC personnel conducting UT examination on the following OBG components: 20TR2-036, 20TR2-037, 20TR2-038, & 20TR2-044.

This QA inspector performed VT of approximately 100% of the area previously tested and accepted by ZPMC Quality Control personnel. All components were as listed on NWIT notification no. 08472. The member(s) is/are identified as OBG Sub Assembly (cable trays) identified as noted below:

- 1. SA6510B, SA6510C, SA6509B, SA6509F, SA6015C, SA6509J.
- 2. SA6509B, 6509H, SA6510B, SA6510A, SA6015B, SA6509E.
- 3. SA6510B, SA6514A, SA6514A, SA6509H, SA6509E, SA6509E.
- 4. SA6509H, SA6510D, SA6509K, SA6509A, SA6513B, SA6525C.
- 5. SA6509G, SA6509F, SA6509E, SA6509H, SA6512A, SA6509D.
- 6. SA6509G, SA6015B, SA6510D, SA6513A, SA6509B, SA6015B.
- 7. SA6015A, SA6509L, SA6509E, SA6510B, SA6509L, SA6509E.

## WELDING INSPECTION REPORT

(Continued Page 2 of 3)

8. SA6015D, SA6015D, SA6015B, SA6510B, SA6524C, SA6509E.

#### Bay Number 3

FCAW welding of fillet welds located on Sub Assembly component identified as SA8008-001 weld no.(s) 001~006. Welder is identified as welder no. 208035. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2132-ESAB.

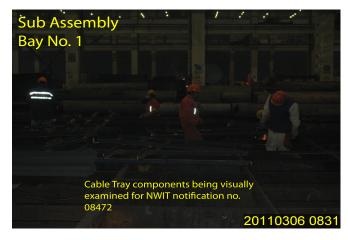
FCAW welding of fillet welds located on Sub Assembly component identified as SA8008-001 weld no.(s) 025~033. Welder is identified as welder no. 050977. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-T-2132-ESAB.

#### Bay Number 8

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. All components were as listed on NWIT notification no. 08473. The member(s) is/are identified as OBG Bike Path identified as noted below with the following weld no.(s):

- 1. BK4ASD1-063-001~004, 022~024, 027.
- 2. BK004A4-060-061.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents



#### **Summary of Conversations:**

Pertinent conversations are included in the body of the report.

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

# WELDING INSPECTION REPORT

(Continued Page 3 of 3)

**Inspected By:** Hernandez,Rene Quality Assurance Inspector **Reviewed By:** Hall,Steven QA Reviewer